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D4753-1**Job Sheet 192292****Part No:** D4753-1**Job Qty:** 150 pcs**Part Name:** Doubler**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 3/20/19**Job Tracking No:****Due Date:** 3/29/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG REV A IPP REV:A NEW ISSUE 13-02-21 JLM VERIFIED BY:DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	150 pcs		3/29/19	0.00	4.50	Waterjet - Flow		dc 19/04/03
110	QC 2	150 pcs		3/29/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		dc 19/04/03
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		

					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
120	HAAS 5 Axis - B4B	150 pcs	3/29/19	0.00 10.80	HAAS - 5 - B4B HAAS 5 AXIS	MMML 19/04/09
140	QC 8	150 pcs	3/29/19	0.00 0.00	QC 8 - 12	SB 19/04/09
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
150	Small Fab - 2 - B4B	150 pcs	3/29/19	0.00 1.78	Small Fab - 1 - B4B	DAS 58 APR 09 2019
					Small Fab - 2 - B4B	9-89
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
160	QC 5	150 pcs	3/29/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
170	Handfinish - 1-1 Chemical-B4B	150 pcs	3/29/19	0.00 1.25	Handfinish - 1 - 1 - B4B	DAS 40 APR 10 2019
					Handfinish - 1 - 2 - B4B	9-89
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 -	

				B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	P.R 19/04/10
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
180 QC 7	150 pcs	3/29/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	

APR 10 2019

QC 7 - 40					
190	Packaging 3-1 - Stock - B4B	150 pcs	3/29/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B

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200 QC 21 - SA

150
pcs

3/29/19

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 53

APR 11 2019 70

DAS

70

8.89

Part Op 100 - 1-Cut as per Dwg D4753 Dwg Rev: A Prog Rev: A4 ***.758" DIA HOLE TO BE OPENED TO FIN
 Descriptions: SIZE BY SKID DEPARTMENT UPON INSTALLATION** 3- Deburr if necessary
 110 - QC2- Inspect parts off machine FAI/FAIB
 120 - HAAS CNC Vertical Machine - Machine as per Folio FB163 and Dwg D3506 FOLIO REV: A4 DWG
 REV: A ***.758" DIA HOLE TO BE OPENED TO FIN SIZE BY SKID DEPARTMENT UPON INSTALLATION**
 140 - QC8- Inspect parts - second check
 150 - C'sink as per Dwg D4753 (On Flat side)
 160 - QC5- Inspect part completeness to step on W/O
 170 - Chemical Conversion Coat per QSI005 4.1
 180 - QC7-Inspect Chemical Conversion Coat
 190 - Identify as per dwg & Stock Location: LOCATION : LG001
 200 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.125	6061-T6 .125 Sheet	2.0700 sf (.0138 ea)	100-Waterjet - Flow - 1	SO/8009

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.125	2	44	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.128Inches + 0.005 - 0.001	0.133 0.127	Diameter	.128
2	Doubler	0.500Inches ± 0.010	0.510 0.490		.501
3	Doubler	1.000Inches ± 0.010	1.010 0.990		1.00
4	Doubler	0.750Inches ± 0.010	0.760 0.740		.740
5	Doubler	1.500Inches ± 0.010	1.510 1.490		1.501
6	Doubler	2.000Inches ± 0.010	2.010 1.990		1.990
7	Doubler	0.126Inches ± 0.010	0.136 0.116		.120
8	Doubler	3.540Inches + 0.012 - 0.001	3.552 3.539	Diameter	
9	Doubler	0.126Inches ± 0.010	0.136 0.116		

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QCs SBL 29/04/09

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S169505

Part: D4753-1

Job No: 192292

Serial No/Batch: S169505

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/04/19